

Date: Wednesday, 28/01/2009 5:00:01 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LONG PIN BRACKET
Job Number : 45327	
Estimate Number : 11204	
P.O. Number :	Part Number : D333011
This Issue : 28/01/2009 S.O. No. :	Drawing Number : D3330 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : D
Previous Run : 45176	Material :
Written By :	Due Date : 10/02/2009 Qty: 6 Um: Each
Checked & Approved By : <u>JULIE DAWSON</u>	
Comment : Est. A05.01.13 New issue KJ/JLM est b 07.05.14 rev c dwg ec est C 07.12.12 rev D dwg EC verified by:DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	*M1010B2500X01000	1010-1025 Steel Bar 2.50 x 1.00



Comment: Qty.: 0.4437 f(s)/Unit Total : 2.6624 f(s)
 1010-1025 Steel Bar
 Material: AISI 1010-1025 or ASTM A36/A366/A569/A570 Cold Rolled Steel(
 M1010-B2.500x01.000)
 Identify for D3330-11
 Batch: M110740

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks: 2.500" x 1.000" x 5.00" long (+/-0.030)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA479 and Dwg D3330
 Identify as D3330-11
 Deburr

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3330-11 PAR #: N/A Fault Category: Prod/Machined Parts NCR: Yes No DQA: D Date: 09/02/11
 Resolution: Documentation Revised Disposition: Scrap QA: N/C Closed: D Date: 09/02/11

NCR: <u>45327</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/02/05	3.0	1 Part scrap 1/2 endmill fell out during machining. Tool was not tight enough in the holder	<u>AB</u> <u>09/02/05</u>	changed holder in folio SCRAP and Destroy <u>09/02/05</u> and Replace m 110740	<u>M.A</u> <u>09/02/05</u>	<u>S</u> <u>09/02/05</u>	<u>AB</u> <u>09/02/05</u>	<u>S</u> <u>09/02/05</u>
		Re. wrong holder						

NOTE: Date & initial all entries

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Drawing Name: LONG PIN BRACKET

Job Number: 45327

Part Number: D333011

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JS 09/02/06

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Carl

JS 09/02/09

(x6)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/09 JS

Job Completion



MF 09-02-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: <u>HL5821</u>
Description: Long Pin Bracket		Part Number: D3330-11
Inspection Dwg: D3330	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

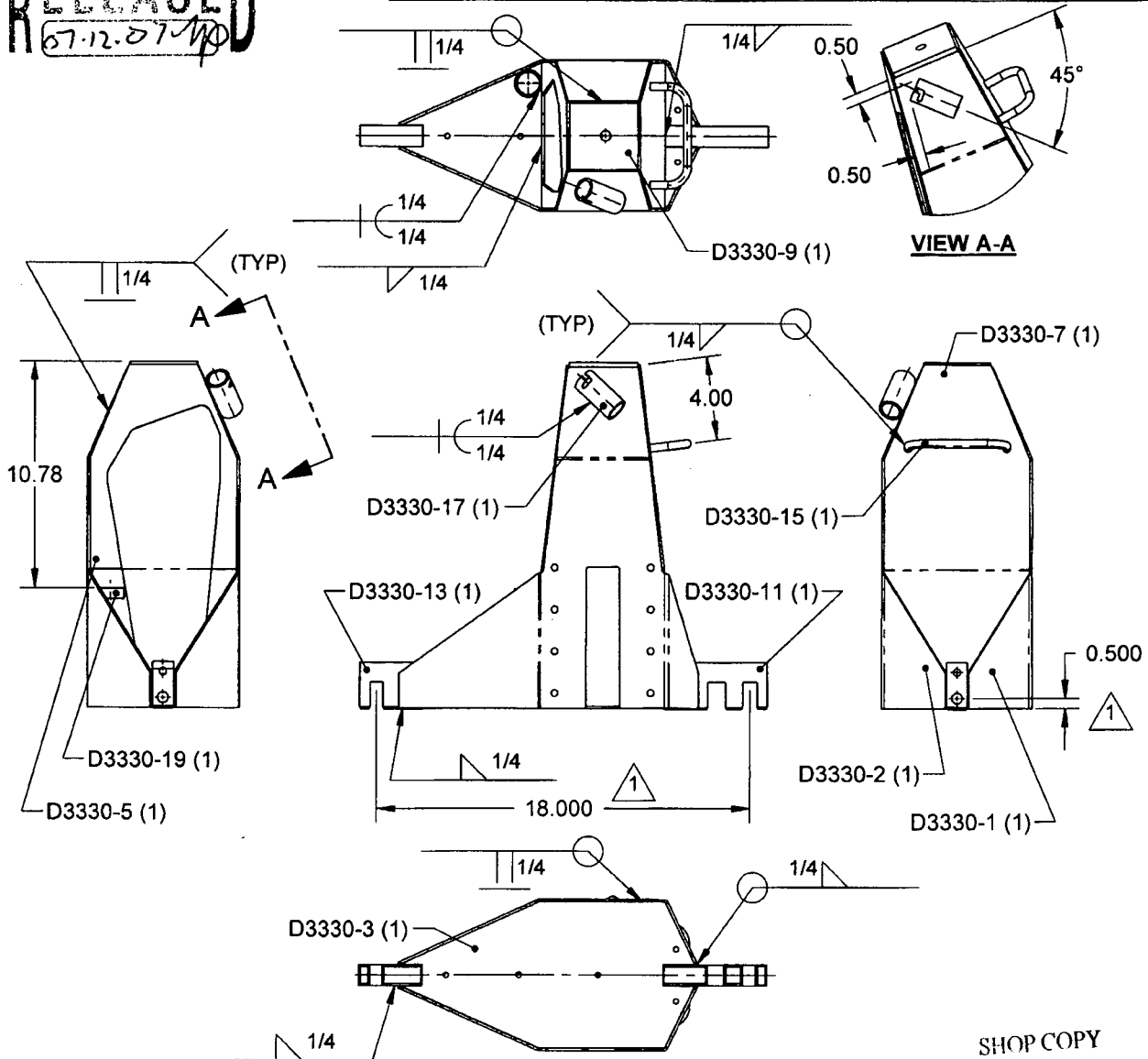
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.00	+/-0.030	4.997	✓			
4.625	+/-0.010	4.623	✓			
0.260	+/-0.010	0.258	✓			
Ø0.594	+0.005/-0.000	0.595	✓			
0.875	+/-0.010	0.878	✓			
0.838	+/-0.010	0.837	✓			
0.700	+/-0.010	0.701	✓			
0.500	+/-0.010	0.500	✓			
2.25	+/-0.030	2.249	✓			
0.950	+/-0.010	0.949	✓			
Ø0.531	+0.005/-0.000	Ø0.536	✓			
Ø0.348	+0.005/-0.000	.348	✓			
Ø0.516	+0.005/-0.000	Ø0.521	✓			
0.467	+/-0.010	0.471	✓			
1.250	+/-0.010	1.247	✓			
1.00	+/-0.030	0.999	✓			
0.10 x 45°	+/-0.5°	0.105 x 45°	✓			

Measured by: <u>M.A</u>	Audited by: <u>SP</u>	Prototype Approval: N/A
Date: <u>09/02/05</u>	Date: <u>09/02/06</u>	Date: N/A

Rev	Date	Change	Revised by	Approved
A	05.05.10	New Issue	KJ/JLM	
B	06.03.09	Dwg Rev updated	KJ/JLM	
C	07.05.16	Dwg Rev updated	KJ/EC	
D	07.11.23	0.838 was 0.837	KJ/EC/DD	<u>DD</u>

DART**RELEASED**
07.12.07

DESIGN 13	DRAWN BY DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 13	APPROVED WFP	DRAWING NO. D3330	REV. D SHEET 1 OF 9
DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:8
REV	DATE	DESCRIPTION	
A	04.12.16	NEW ISSUE	
B	05.02.26	RE-DESIGN	
C	07.03.20	ADD 0.100 DIM; RAISED BEND OF -1/2 BY 0.125	
D	07.12.06	CHANGE DIMS ON D3330-9	

**D3330-041 FRAME WELDMENT****NOTES:**

- 1) POSITION PARTS AS PER JIG D3330-041T1
- 2) WELD PER QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

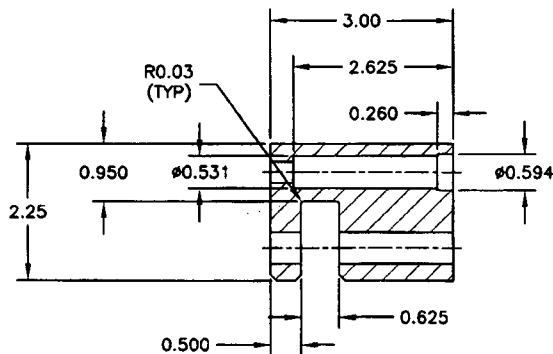
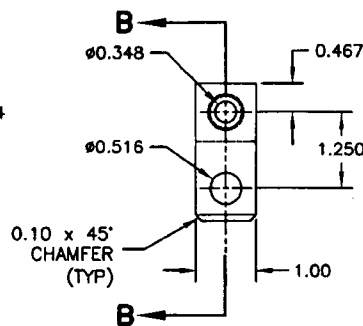
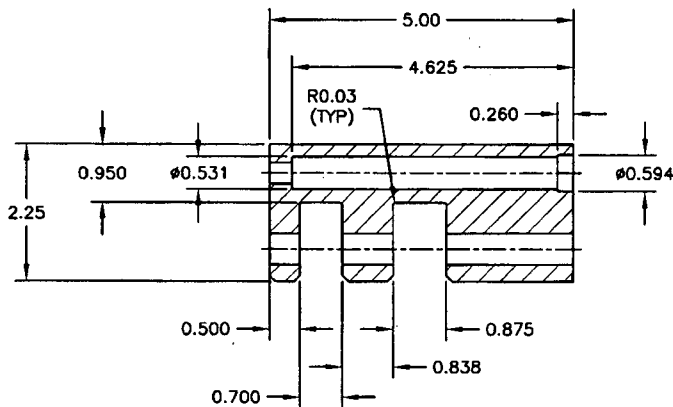
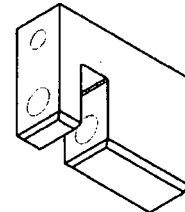
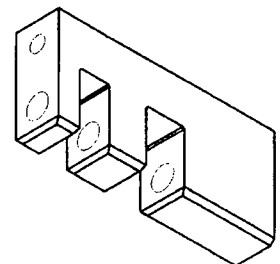
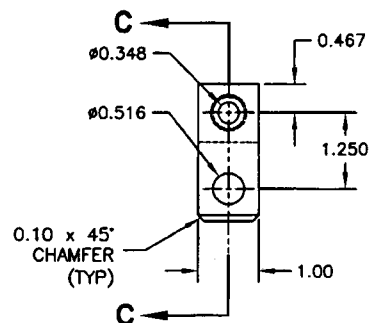
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DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>DC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3330	REV. D SHEET 9 OF 9
DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:3

**SECTION B-B****D3330-13 SHORT PIN BRACKET****RELEASED**
07.12.07 *[Signature]***SECTION C-C****D3330-11 LONG PIN BRACKET****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.000 THICK (REF. DART SPEC. M1010-B1.000x02.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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